

OK Autrod 12.62

A Tripple desoxidized copper coated solid wire for GMAW of mild and fine grained structural- and pressure vessel steels as well as ship building steels. The wire electrode is capable of producing high quality welds in semi-killed and rimmed steel as well as steel of various carbon levels. Because of added desoxidants, Al-Ti-Zr, the wire electrode can also be used for welding steels with a rusty or dirty surface, without any sacrifice of weld quality.

Tekniska data

Klassificeringar

EN ISO 14341-A : G 42 3 C1 2Ti
 EN ISO 14341-A : G 46 4 M21 2Ti
 EN ISO 14341-A : G 2Ti
 SFA/AWS A5.18 : ER70S-2

Legeringstyp

Carbon-manganese steel (Mn/Si-alloyed)

Skyddsgas

80Ar/20CO₂, CO₂

Typiska mekaniska värden

Villkor	Sträckgräns	Brottgräns	Förlängning
80Ar/20CO₂ (M21) EN			
Helsvetsgods	570 MPa	625 MPa	26 %

Svetsgodsanalys %

C	Mn	Si	S	P
CO₂ (C1)				
0.05	0.72	0.46	0.010	0.010
80Ar/20CO₂ (M21)				
0.07	0.85	0.51	0.010	0.010

Trådens sammansättning %

C	Mn	Si
0.06	1.1	0.6

Insmålningsdata

Diameter	Ström	Bågspänning	Trådmatningshastighet	Insvetstal
0.8 mm	60-200 A	18-24 V	3.2-10.0 m/min	0.8-2.5 kg/h
0.9 mm	70-250 A	18-26 V	3.0-12.0 m/min	0.8-3.3 kg/h
1.2 mm	120-380 A	18-35 V	2.5-15.0 m/min	1.3-8.0 kg/h